

Date: Thursday, 28/08/2008 1:16:39 PM
 User: Melanie Fauteux

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ANGLE
 Job Number : 41656 Estimate Number : 13281
 P.O. Number : Part Number : D36981
 This Issue : 28/08/2008 S.O. No. : Drawing Number : D3698 REVB
 Prsht Rev. : NC Project Number : N/A
 First Issue : 11 Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 41022 Material :
 Due Date : 04/09/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : MF 08-08-28
 Comment : Est Rev:A 08-04-25 new issue DD verified by:EC
 Est Rev:B 08-07-14 revB as per dwg DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 0.4700 sf(s)/Unit Total : 3.7598 sf(s)
 6061T6 aluminium sheet .032" thick
 (M6061T6S032)
 Batch: 18315 B 8-8-29

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3698
 Dwg Rev: B B 8-8-29
 Prog Rev: B
 ****grain direction along 1.378" ****

2- Deburr if necessary B 8-8-29

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/08/29 (11)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Bend 105 deg. angle as per Dwg D3698

S 08/09/02 (11)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ANGLE

Job Number: 41656

Part Number: D36981

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-form curve as per dwg D3698 and verify using template DT9001

FF 08/09/09 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/09 @

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 08/09/09 (1)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8 08/09/09 @

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: QA

used on B41207 D 3696-041

FF 08/09/09 (1)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

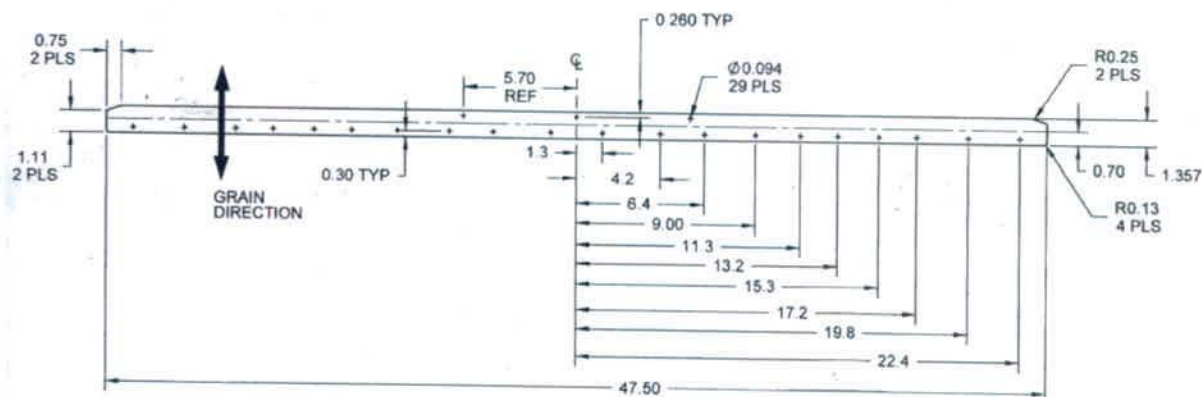
08/09/10

Job Completion



MF 08-09-09

D3698-1 SUPPORT ANGLE
(MAKE FROM D3698-1F FLAT PATTERN)



D3698-1F FLAT PATTERN



SECTION A-A

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK (REF. DART SPEC. M6061T6S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.20 lbs
- 8) FORM AS PER TEMPLATE DT9001

B	REMOVE POWDER COAT, ZONE A.B	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	SUPPORT ANGLE	
DATE	08.06.02	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED, REPRODUCED, COPIED, OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

D 3698-1

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Prototype

Measured by:	AB	Audited by:	S	Prototype Approval:	A
Date:	8-8-21	Date:	08/06/21	Date:	17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

